April-04-13 3:32:51 PM

Item ID: Revision ID:	D2221			Accept	*N.900	1040	100)* s	etup Star	* N	S1*
Item Name:	350 Basket Base								Stop	• *N	S2*
Start Date:	4/04/13 Start Q	ty: 1.00	*1*		Cust Item	ID:					
Required Date:	4/18/13 Req'd	Qty: 1.00	*1*		Customer:						
Reference:			•				•				•
Approvals:	Process Plan: _M_	5	_ Date:/3-04-04	Tooling:	D	ate:		R	tun Star	I/I	R1*
	QC:		,		D	ate:			Stoj	ໍ *N	R2*
Sequence ID/ Work Center II	Operati D Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r									
D2221	Rev H										
100				0.00					0.4		
100	Large Fab)							DY /	CC 1.	3-4-11
Large Fab		Memo		0.00							
Large Fab		2- remove dwg D222 3- tack wel A/R EF ***PLEAS	e all ribs and both D2581 in I basket from jig and weld D34 I I I I I I I I I I I I I I I I I I I	42-1 shims and D2232 D2221 122357 G ON BASE BOTH EN	-3 hinges as per				•		
110	QC9- Insp	pect visual per	r QSI004- Fusion Welds	0.00							DAS
110 QC Quality Control		Memo		0.00					13-0	4 <u>-11 (</u>	09 2-8 3

NCR:	Yes	1	No
IVCN.	162	,	140

NCR:	es/	/ No					WORK ORDER NON-C	Or.	NFORM	MANCE / UPI	DATE	0.4.01	ъ.	e e e e e e e e e e e e e e e e e e e			
						_		_				QA Closed:	Date:	·			
Nork Orde	er:						DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part No. Rework										Skid-tube Aachining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
NCR I	No.						Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	Other				
Root					Desc	ript	tion of work order update		nitial	Act	tion	Sign &	-				
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector			
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		Bending			· L	_	Bend	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Grain			Ovalized	<u> </u>	Pressure/Forced			
	<u> </u>	Centre No	ot Concer	ntric to	o/s	_	BOM/Route	Ш	Hardwa		ļ	Over/Under	<u> </u>	Temperature/Cure			
	_	Cracks			L	—	Broken/Damaged		1	on incomplete		Part Incorred	<u> </u>	Weld			
		Crushed/0	Crimped		_		Burrs		1	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	_	Cuffs			L	_	Contamination	<u> </u>	Mainte		<u> </u>	Part Moved					
		Heat Trea				4	Countersink	<u></u>	Mislabe	led	1_	Positioned V		,			
		Inspection	•	Tube	L	_	Cut Too Short		Misread	Surge	Other						
		Ripples in					Drill Holes	<u></u>	Offset								
		Torque W	aves in E	xtrusio	n L	_[Drawing			Calibration							
		Turning S	equence			_	Finish		Out of S	equence							
	Wave/Twist in Tube Folio Outside Dimensions																

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April-04-13 3:32:51 PM

Item ID: D2221 Accept *N900040100* Setup Start **Revision ID:** Item Name: 350 Basket Base Start Qty: 1.00 **Start Date:** 4/04/13 **Cust Item ID:** Required Date: 4/18/13 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: ____ Date: ____ Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Code Qty Qty Number Stamp **Run Hours** 120 QC6- Inspect dimensions to drawing 0.00 *120* 0.00 Memo Quality Control 125 Pressure Wash per QS1005 4.3 0.00 *125* HandFinish 0.00 Memo Hand Finishing

NCR:	Yes	1	No
INCh.	162	/	140

DQA:

Date:

NCR: Y	es / No)			WORK ORDER NON-	CONF	ORN	MANCE / UP	DATE			
	•									QA Closed:	Date	•
Nork Orde	r:				DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
Part N	o				Rework Scrap		١	Skid-tube // // // // // // // // // // // // //	Crosstube Small Fab	⊣	Water Jet d. Eng. Coor	Engineering Quality
NCR N	o				Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	ial	Ac	tion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
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upplier												1
raining												
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[Bendir	ng			Bend	Gr	ain			Ovalized		Pressure/Forced
[Centre	Not Conce	entric to	o/s	BOM/Route	Ha	rdwai	re	_	Over/Under	tolerance	Temperature/Cure
. [Cracks				Broken/Damaged	Ins	pection	on Incomplete		Part Incorred	t _	Weld
. [Crushe	ed/Crimped	t		Burrs	Ins	structi	ons Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	M	ainte	nance		Part Moved		
Ī	Heat T	reat			Countersink	Mi	islabe	led		Positioned V	/rong	_
	Inspec	tion Strip i	n Tube		Cut Too Short	Mi	isread			Power Loss/	Surge	Other
ľ	Ripple	s in Bend			Drill Holes	Off	fset					
	Torqu	e Waves in	Extrusio	n	Drawing	Ou	it of C	alibration				
	Turnin	g Sequenc	e		Finish	Ou	ıt of S	equence				
	Wave	Twist in Tu	ıbe		Folio	Ou	ıtside	Dimensions				

99260

April-04-13 3:32:51 PM

Quality Control

D2221 Accept Item ID: *N900040100* Setup Start **Revision ID:** Item Name: 350 Basket Base Start Qty: 1.00 **Start Date:** 4/04/13 **Cust Item ID:** Required Date: 4/18/13 Reg'd Oty: 1.00 **Customer:** Reference: Run Process Plan: ____ Date: ___ Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Set Up/ Sequence ID/ **Operation** Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Code Qty Qty Number Stamp **Run Hours** 130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00 *130* Powdercoat Memo Powder Coating 1- Plug holes prior to M125069 START TIME: OVEN TEMPERATURE: FINISH TIME: QC3- Inspect Part Finish 140 0.00 *140*

0.00

Memo

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	MANCE / UPI	DATE	QA Closed:	 Date	
	<u>;</u>				DISPOSITION				AGAINST DE			·
Work Orde Part N NCR N	lo.	ļ			Rework Scrap Use-as-is Work Order Update Skid-tube Machining Machining Thermoforming Large Fab Composite			-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root		1		Descri	ption of work order update	ln	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AULT	CATE	GORY				
Landir [ng Gear Bending Centre N Cracks	lot Conce	ntric to (D/S	General Bend BOM/Route Broken/Damaged		Grain Hardwa Inspecti	re on Incomplete		Ovalized Over/Under Part Incorre	 	Pressure/Forced Temperature/Cure Weld
	Crushed/Crimped Cuffs Heat Treat				Burrs Contamination Countersink Cut Too Short		Maintenance Mislabeled			Part Lost/Mi Part Moved Positioned V Power Loss/	Vrong	Wrong Stock Pulled Other
ł	Inspection Strip in Tube Ripples in Bend				Drill Holes	\vdash	Misread Po Offset					Total

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drawing

Finish

April-04-13 3:32:51 PM

Item ID: D2221 Accept *N900040100* Setup Start **Revision ID:** Item Name: 350 Basket Base 4/04/13 Start Qty: 1.00 *1* **Start Date: Cust Item ID:** Required Date: 4/18/13 Req'd Qty: 1.00 *1* **Customer:** Reference: Run Date:_____ Approvals: Process Plan: _____ Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Tool ID **Operation** Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp Identify as per dwg & Stock Location() 150 *150* Packaging 0.00 Memo Packaging 160 QC21- Final Inspection - Work Order Release 0.00 *160* QC 0.00 Memo Quality Control

RIB-09-17

NCR: Y	es/	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE						
									-		QA Closed:	Date	:			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
	 	Rework Skid-tube Scrap Machining Use-as-is Thermoforming Work Order Update Large Fab								Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root					Descri	ption of work order update	I	nitial	Act	tion	Sign &					
Cause		Date ⁱ	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector			
Doc/Data																
Equip/Tooling		i									İ					
Operator																
Material			1				Ì									
Setup																
Other																
Process	Щ	:	-													
Supplier	Ц															
Training			1													
Unapproved			L	L			<u> </u>				L					
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Landi	$\overline{}$					General		ا ما		_	1	_	7s			
	\vdash	Bending			a (c	Bend	\vdash	Grain		<u> </u>	Ovalized	A-1	Pressure/Forced			
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	Н	Cracks	o :		<u> </u>	Broken/Damaged	\vdash	1 '	ion incomplete	la da a	Part Incorred	-	Weld			
	_	Crushed/0	Crimped		·	Burrs	-	l	ions Incomplete/U	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
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	—	Ripples in			<u>,</u> ⊢	-	\vdash	ł	Calibration		W					
!	-	Torque W			-	Drawing Finish	\vdash	1	Sequence							
	l I	Turning S	equence		1	[FIIII5]]	1	logr or s	pequence							

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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Picklist Print

April-04-13 3:32:54 PM

Work Order ID: 99260

99260

Parent Item:

D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/04/13

Required Date: 4/18/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM

IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC

IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N

10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1		Manufactured	No			100	Each	8.0000	l	1			The second secon
D2221-1									**	B90	856 A	SY is	3-04-05
				Location	!	Loc	<u>Oty</u>	Loc Code		,			
				WA005			8		_		_		*
					86847		1		· -		_		
					90856		4		_		_		
					98418		3		_		-		
D2221-5		Manufactured	No			100	Each	8.0000	2	2		•	
D221-5									** <	B 940	073 ÷	2X	
				Location	!	Loc	<u>Oty</u>	Loc Code				SY 1	3.04-05
				WA004			8				_		
					94273		8		_			i.	
D2221-7		Manufactured	No			100	Each	3.0000	1	1		A	1
D221-7									** <	B 87	1715	Sy	13-04-05
				Location	!	Loc	<u>Otv</u>	Loc Code					
				WA006			3						
					87715		3						

Page 1

											DQA:	Da	ate:	
NCR:	Yes	/ No	*			WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE				
				•					Ţ		QA Closed:	Da	ite:	·
Work Ord	oż.				·	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIL	ег.			· · · · · · · · · · · · · · · · · · ·		Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part f	No.					Scrap	1	3	Machining	Small Fab	Pro	d. Eng. Coor.	⊢	Quality
	•					· • • • • • • • • • • • • • • • • • • •			Finishing	4	re/Packaging	-	Other	
NCR I	No.					Work Order Update]		Large Fab	Composite]	Supplier		
			,								· · · · · · · · · · · · · · · · · · ·			,
Root			,			ption of work order update	1	Initial		tion	Sign &			1
Cause	_	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Doc/Data	Ш				•									
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Operator	Ш	\												
Material .		,			•					e e				
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Other			1											
Process						•								
Supplier							1							
Training														
Unapproved														
		•				F	ΑUI	LT CATE	GORY					
Landi	ing G	Sear				General		_		-	-		_	-
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks			, [Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs	٠,		, [Contamination		Mainte	nance		Part Moved			
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong		_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge		Other
		Ripples in	n Bend			Drill Holes		Offset			=			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Order ID: 99260

D2221

99260 *D2221*

Parent Item Name: 350 Basket Base

Start Date: 4/04/13

Each

Each

46.0000

Required Date: 4/18/13

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Basket Hinge

D2232-3

Parent Item:

Location Loc Oty Loc Code WA004 75581 2 98040 24 98473 20 100 14.0000

100

B 98040 =24 Sy 13-04.05

D2235-1

Manufactured

Manufactured

**

B96126-2X

D2235-1 Basket Rib

Location	Loc (Qty	Loc Code
WA004		14	4
66895		4	
85602		4	
86051		1	
95720		5	
	100	Each	100.0000

D2581

Manufactured No

**

Mounting Bracket

Location	Loc Qty	Loc Code
WA	62	
96599	18	
98503	44	
WA004	38	
70766	2	
81253	1	
82506	2	
83230	3	

2

2

6

20

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Shop Packet Print

85452

87706

97756

98108

Page 2

											DQA:	Date:				
NCR: Y	res /	No				WORK ORDER NON	-CO	NFORI	MANCE / UP	DATE	OA Chanada	Data				
,									 		QA Closed:	Date:				
Work Orde	ar.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
WOIK Gide	=1					Rework	\neg	Skid-tube Crosstube Water Jet Engine								
Part N	No					Scrap			Machining	Small Fab	t	d. Eng. Coor.	Quality			
						Use-as-is	4	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR N	No					Work Order Update			Large Fab	Composite		Supplier				
Root		÷			Descri	ption of work order update		Initial	Ac	ction	Sign &					
Cause	D	ate	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	cription	Date	Verification	QC Inspector			
Doc/Data		:														
Equip/Tooling	Ш						İ		<u>.</u>							
Operator	Ш															
Material	Н						ł									
Setup	Н.	•					ŀ						-			
Other	HÌ.	1				•						1				
Process	H															
Supplier	Ш			ļ			İ									
Training	Щ															
Unapproved			<u> </u>	l	<u> </u>		5011	TCATE	CORY		<u> </u>	<u> </u>	<u> </u>			
							FAU	LT CATE	GUKY							
Landi	ng Gear				_	General	_	1 c:		Γ	Ovalized	Γ	Pressure/Forced			
	i iRen	ding			1	Rend	ı	Grain			iovalized		irressure/rorced			

Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Cuffs Contamination Maintenance Part Moved Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Cut Too Short Misread Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Finish Out of Sequence Turning Sequence

Outside Dimensions

Hardware

BOM/Route

Folio

Temperature/Cure

Over/Under tolerance

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Centre Not Concentric to O/S

Picklist Print

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Work Order ID: 99260 *99260* D2221 *D2221* Parent Item: Parent Item Name: 350 Basket Base **Start Date:** 4/04/13 Required Date: 4/18/13 Start Qty: 1.00 Required Qty: 1.00 D3442-1 Manufactured 100 Each 1.0000 No B 98076+2x St 13.04.05 Loc Qty Loc Code Location WA004 98076 D3825-041 100 Each 8.0000 Manufactured No ** Rib Assembly (Basket End) Location Loc Qty Loc Code WA004 8 97285 D3826-041 Manufactured No 100 Each 2.0000 ** Rib / Gusset Assembly Loc Code Location Loc Qty WA 2 98343 2 D3827-041 100 Each 4.0000 Manufactured **

Loc Qty

Loc Code

Location

WA005

89334

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
											QA Closed:	Date:		
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	~~					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other		
Root			•		Descri	ption of work order update		Initial	Act	ion	Sign &			
Cause		Date.	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
		<u> </u>				<u>-</u> -	AUL	T CATE	GORY					
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	l llo	rque W	aves in E	:xtrusio	n	Drawing	1	Jour of 0	Lation				·	

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-04-13 3:32:55 PM

Work Order ID: 99260

Parent Item:

D2221

99260

Parent Item Name: 350 Basket Base

D2221

Required Date: 4/18/13

Start Date: 4/04/13 Start Qty: 1.00

Required Qty: 1.00

D3832-1 *D3832-1*

Mesh (Base)

Manufactured No

Manufactured

No

100

Each

6.0000

Location Loc Qty Loc Code WA 96614 2 98291 4 100 Each 26,0000

D3833-1

Mesh (Base End Face)

Location Loc Qty Loc Code WA 10 10 98359 WA007 16 77521 4 81259 89208 98538 10

**

											DQA:	Date	e:		
NCR:	Yes /	No				WORK ORDER NON-	COI	NFORM	MANCE / UPDA	TE			,		
											QA Closed:	Date	e:		
Monte Onde	~ 					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Work Orde	er:					Rework			Skid-tube C	Crosstube	1	Water Jet	Engineering		
Part N	No					Scrap	-		├	Small Fab	Pro	d. Eng. Coor.	Quality		
1 01(1	•••.—					Use-as-is	1	1	~ <u>~</u>	Finishing	4	re/Packaging	Other		
NCR N	No.					Work Order Update	┨		~⊢	omposite	1100,5101	Supplier	→ → → →		
							ا ل			٠ ـــ	1	٠. ـ	. .		
Root					Descri	ption of work order update		Initial	Action		Sign &				
Cause	Da	ite	Step	Qty	(or Non-conformance	Ch	nief Eng	Descripti	on	Date	Verification	QC Inspector		
Doc/Data															
Equip/Tooling															
Operator							1								
Material											1				
Setup												:			
Other		1													
Process		-					1		: -						
Supplier	Ш	l			İ										
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							AUI	LT CATE	GORY						
Landi	ng Gear				_	General	_	7			1	Г	 1 .		
Bending						Bend	\perp	Grain			Ovalized	-	Pressure/Forced		
			t Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa		_	Over/Under	⊢	Temperature/Cure		
	Crac					Broken/Damaged	<u> </u>	4 '	on Incomplete	<u> </u>	Part Incorre		Weld		
,			rimped			Burrs		4	ions Incomplete/Uncle	ear	Part Lost/Mi	ssing	Wrong Stock Pulled		
1	Cuff	s [:]				Contamination	1	Mainte	nance	i	Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

ITEM OTY DESCRIPTION X D2221 BASKET BASE ASSEMBLY (AS350) D2221-1 RIB 2 D2221-5 RIB D2221-7 RIB 5 2 D2232-3 BASKET HINGE 2 D2235-1 RIB 6 D2581 MOUNTING BRACKET 2 2 D3442-1 SHIM 8 q D3825-041 RIB ASSY (BASKET END) 2 D3826-041 RIB/GUSSET ASSY 10 D3827-041 RIB ASSY (INBOARD) 11 D3833-1 MESH, BASE END FACE 12 2 D3832-1 13 MESH (BASE) 1

REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); REVISED SECTIONS A-A. B-B AND C-C (ZN C8-3). C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN 82-4); ADDED DWG DETAILS FOR D2221-19-57 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3425-041 REPLACES D2221-3/D2327-3, D3826-041 REPLACES D2235-1/D2327-3, D3827-041 REPLACES D2235-1/D2327-3, D3827-041 REPLACES D2235-1/D1023-2, D3827-041 REPLACES D2235-1/D1023-2, D3827-041 REPLACES D2231-1/D101-3/D101мв 08.09.18 MATERIAL FOR -1, -3, -5 & -7 WAS 0,060 WALL:
TOLERANCE FOR 96,00 DIM WAS +4-0.01 AND 56,00 DIM
WAS REF (ZN BS-2), 165 2D IM WAS "HARD" DIMENSION IS
NOW "REF" (ZN B4-2); NOTE 5 TRANSFERED FROM SHT 1
TO SHT 2; SHT 2 WESH MATERIAL UPDATED; DRAWING
TRANSFERED TO "B" FORMAT AJS 08.06.16 ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET PH 05.06.07 CHANGE HINGE CP Е 01.04.19 D CHANGE LATCH BW 96.06.21 С SEPARATE BASKET AND LID KH 95.11.21 REV. DESCRIPTION BY DATE DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. H D2221 MFG. APPR. SHEET 1 OF 5 TITLE APPROVED BASKET BASE ASSEMBLY (350) NTS DE APPR. COPYRIGHT © 1994 BY DART AEROSPACE LTD
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HOLD TO BE USED FOR ANY PURPOSE OR COMPET ON COMMUNICATED TO MAY OTHER PURPOSE

DATE 08.09.18

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

9) MASK ALL HOLES PRIOR TO POWDER COATING

D2221 BASKET BASE ASSEMBLY (AS350) (MESH SHOWN LOCALLY FOR CLARITY)

										DQA:	Date	•
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	AANCE / UP	DATE	QA Closed:	Date	
·					DISDOSITION				A CAINCT DE			•
Work Orde	er:				DISPOSITION	i			AGAINST DE	PAKTIVIENT	PROCESS	
					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.				Scrap	crap Machining Small Fab Prod. Eng. Coor.					d. Eng. Coor.	Quality
					Use-as-is		Therm	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab	Supplier			
Root				Descri	tion of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material		ļ										
Setup												
Other												
Process		ļ										·
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Training												
Unapproved												
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	Bending			<u> </u>	Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (D/S	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		1	on incomplete		Part Incorre		Weld
	Crushed/	Crimped			Burrs		1	ons Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> -</u>	Contamination		Mainte			Part Moved		
	Heat Tre	at			Countersink	\vdash	Mislabe			Positioned V	_	7
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

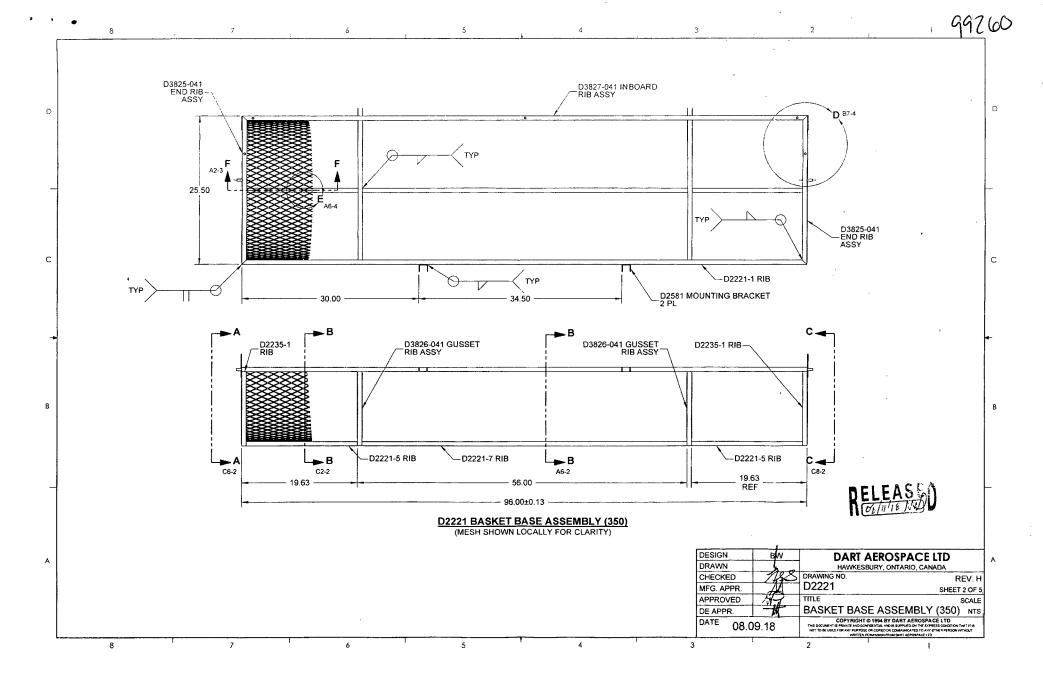
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



										DQA:	Date	e:
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	MANCE / UPI	DATE	QA Closed:	 Date	·
	·				DISPOSITION				AGAINST DE			
Work Orde	eri:					,				<i>-</i>	_	
Part N	lo				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	R No				Work Order Update]		Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	11	nitial	Act	tion	Sign &	- "	
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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	Cracks			<u> </u>	Broken/Damaged	Ш	Inspecti	on Incomplete	ļ	Part Incorred	ct _	Weld
	Crushed/	Crimped			Burrs	Ш	Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ļ	Cuffs				Contamination		Mainte	nance		Part Moved		
Į	Heat Trea	at			Countersink	Ш	Mislabe	led	<u> </u>	Positioned V	Vrong	 -
	Inspection	n Strip in	Tube		Cut Too Short	\square	Misread	l		Power Loss/	Surge	Other
ſ	Ripple's in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

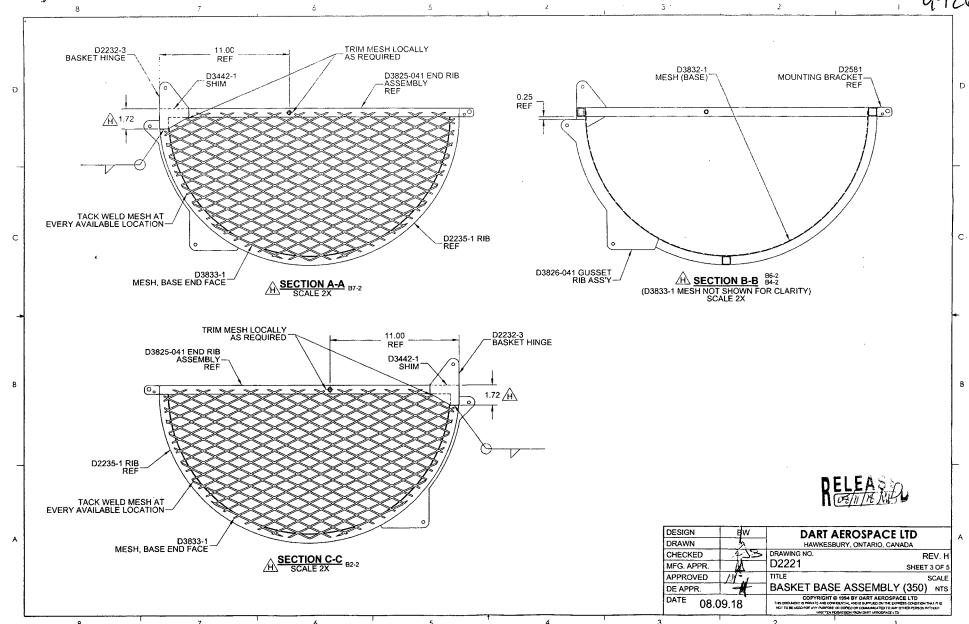
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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NCR: Y	·												
	•									QA Closed:	Dat	e:	
Work Orde	5 r.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Compos			Pro Rec/Stoi	Engineering Quality Other		
Root	i			Descri	ption of work order update	1	nitial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data	i												
Equip/Tooling													
Operator								1					
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Landi	ng Gear			·	General		_			_	_		
	Bending				Bend		Grain			Ovalized	1	Pressure/Forced	
	Centre N	ot Conce	ntric to (o/s [BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	it [Weld	
	Crushed/	Crimped			Burrs		Instruct	tions Incomplete/U	Jnclear	Part Lost/Mi	ssing [Wrong Stock Pulled	
	Cuffs i				Contamination		Mainte	enance		Part Moved	_		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong _		
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other	
	Ripples in	n Bend			Drill Holes		Offset						
	Torque V	Javes in I	Extrusio	,	Drawing		Out of a	Calibration					

Out of Sequence

Outside Dimensions

DQA:

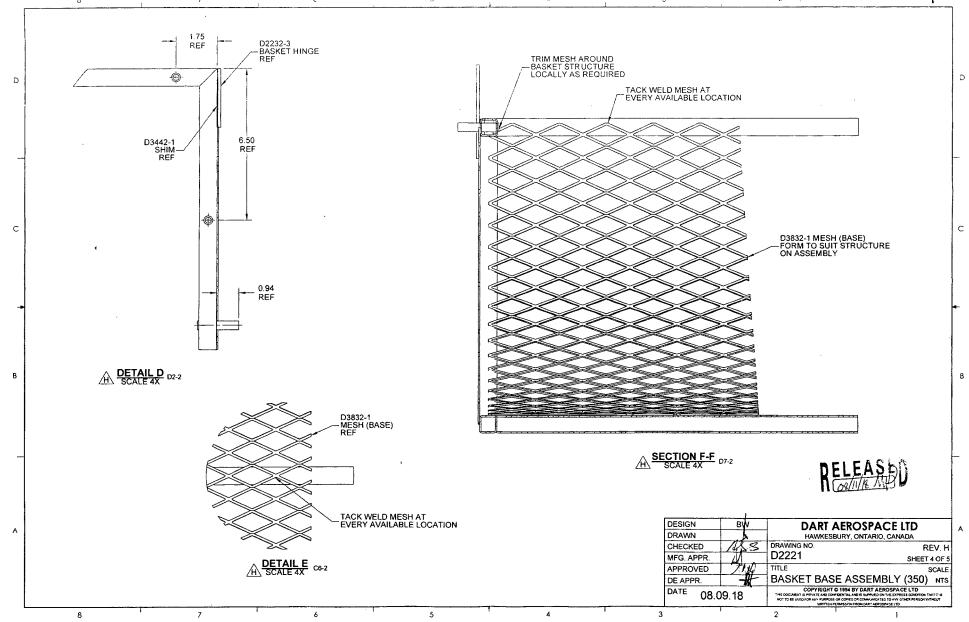
Date:

Turning Sequence

Wave/Twist in Tube

Finish

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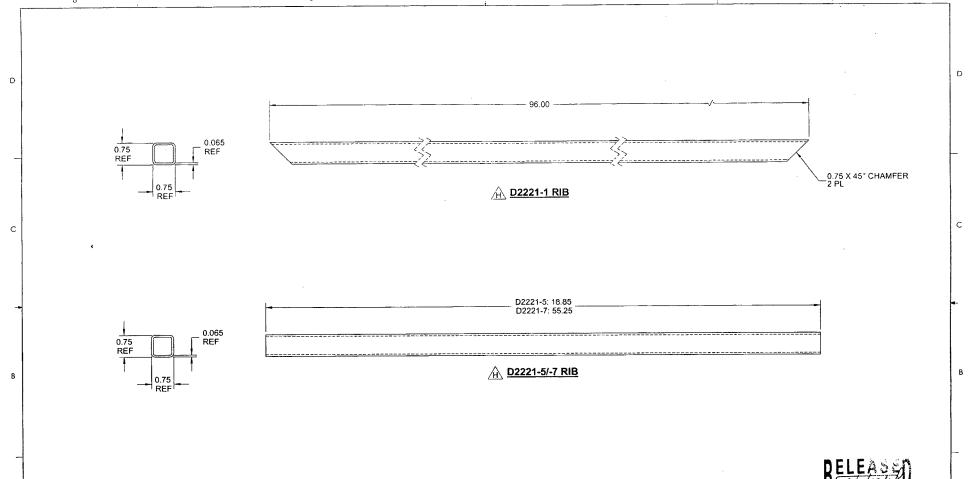
DQA:_	Dat	e:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Dat	e:			
Work Order	; .				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS				
Part No	o				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other				
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector			
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training														
Unapproved		L	<u> </u>		Ε	AULT CAT	FEORY		1					
Landin	g Goor				General General	AULI CAI	LGONT							
	e Date Step Oty				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Instru Main Misla Misre Offse	vare ction Incomplete ctions Incomplete, tenance peled ad	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
Γ							Outside Dimensions							

99260



NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. H D2221 MFG. APPR. SHEET 5 OF 5 APPROVED TITLE SCALE BASKET BASE ASSEMBLY (350) NTS DE APPR. DATE 08.09.18

3

DQA: _____ Date: ____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:	
Work Ordei	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	:
Part No					Rework Scrap Use-as-is	Ther	Skid-tube Crosstube Machining Small Fab ermoforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR No.					Work Order Update		Large Fab	Composite		Supplier	
Root	Root Desc				ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
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quip/Tooling						Ì			ļ		
Operator											
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etup											
Other											
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Supplier											
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					F/	AULT CAT	GORY				
Landin	g Gear			_	General				7	_	,
1	Bending			L	Bend	Grain		<u> </u>	Ovalized		Pressure/Forced
L	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw	are	ļ	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete	<u></u>	Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	instruc	tions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat Trea	at		L	Countersink	Mislab	eled		Positioned V	Vrong	-
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	ıd		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offset					<u> </u>
	Torque W	/aves in E	extrusio	n _	Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of	Sequence				
ſ	Maria /Tir	.:			Folio	1 10	a Dimonsions				